

Work Order ID 53825-1

November 19, 2009 8:37:25 AM



Beaupaw

Page 1

Item ID: D4013-041
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 11/19/2009 Start Qty: 18.00
 Required Date: 11/23/2009 Req'd Qty: 18.00
 Reference:

split ①
4

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *mf*
 QC:

Date: *09-11-19*

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description
Draw Nbr	Revision Nbr
D4013	C

Set Up/
Run Hours

Draw Number Draw Rev. Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp



Waterjet
 FLOW CNC Waterjet

0.00

Memo
 1-Cut as per Dwg D4013-1
 Dwg Rev: *E*
 Prog Rev: *C*

0.00

2-Deburr if necessary

1B 9-11-19

(PK) 7



QC
 Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1B 9-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53825

November 19, 2009 8:37:25 AM

Page 2



Accept



Setup Start



Stop



Item ID: D4013-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/19/2009 Start Qty: 18.00

Required Date: 11/23/2009 Req'd Qty: 18.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

→ Serial 17

(419)

Took
Qty
For
Temp

130



Brake NC

Brake NC

Bend as per dwg

Memo

0.00

0.00

Serial 20

19

6

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

→ Serial 20

(419)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 53825

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Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/19/2009 Start Qty: 18.00

Required Date: 11/23/2009 Req'd Qty: 18.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

150



Large Fab

Large Fab

Operation
Description

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

1- Weld cup, stud as per dwg use DT9550
A/R S.S. ROD BATCH: M108160

2- Apply hardfacing on wearplate and on studs (studs only 5 places not the cups)
as indicated on dwg

A/R HARDCOAT 2059B BATCH: M112963

EL

9-11-23

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

275071624

Ⓢ

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PD 09.11.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 53825

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Page 4

Item ID: D4013-041
Revision ID:
Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 11/19/2009 Start Qty: 18.00

Required Date: 11/23/2009 Req'd Qty: 18.00

Reference:



Cust Item ID:

Customer:

Approvals: Process Plan:
QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QS1005.4.3

M109091

START 9:00

OVER 3200

Memo

FINISH 9:30
***MASK THREADS AND HEXAGONAL OPENING PRIOR TO
PAINTING***

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

62 09-11-24



190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

7 m-k 09/11/24 (42)

200



Packaging

Packaging

Identify as per dwg & Stock Location:

THERMOFORMING BB

09/11/24 X4

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4013-041
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Item Name: Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 11/19/2009 Start Qty: 18.00

Required Date: 11/23/2009 Req'd Qty: 18.00

Reference:



Cust Item ID:

Customer:

Approvals: Process Plan:
QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

09/11/24

ME
09-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

November 19, 2009 8:37:25 AM

Work Order ID: 53825

Parent Item: D4013-041

Parent Item Name: Wearplate Assembly

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
RevB prelim per ECN09-698p 09.11.02 DD verified by:EC
redesign 09.11.12 DD verified by:EC

IPP RevB:

IPP RevC:

IPP RevD: revC as per

Start Date: 11/19/2009

Start Qty: 18.00

Required Date: 11/23/2009

Required Qty: 18.00

M304S16GA



304/316 Sheet .063

Purchased No

100 sf

190.6742 18.3789



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT

190.6741737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

119.3

Manufactured No

150 Each

20.0000

54.0000



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

WA

53183

53827 x 12

20

Manufactured No

150 Each

0.0000

108.0000



53828 x 24

20

Manufactured No

150 Each

0.0000

36.0000



53829 x 6

20

Manufactured No

150 Each

0.0000

36.0000



53830 x 6

Page 1

B9-11-19

20

112885

EL 9-11-23

EL 9-11-23

EL 9-11-23

EL 9-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53875
Description: WEARPLATE ASSEMBLY		Part Number: D4013-041
Inspection Dwg: D4013-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .750	+ .005 - .001	.751	X			
Ø .675	+ .008 - .001	.671	X			
Ø 1.88	+ .010 - .005	1.873	X			+/- 0.030 02/11/19
.675	± .010	.673	X			MAKE
2.938	± .010	2.933	X			PERMANENT
6.876	± .010	6.875	X			CHG.
7.271	± .010	7.272	X			
12.146	± .010	12.146	X			
14.458	± .010	14.458	X			
18.458	± .010	18.458	X			
23.458	± .010	23.458	X			
25.04	± .030	25.04	X			
.750	± .010	.748	X			
1.750	± .010	1.751	X			
1.50	± .030	1.503	X			
2.125	± .010	2.125	X			
2.75	± .010	2.751	X			
.663	± .010	.658	X			

Measured by: IB	Audited by: D	Prototype Approval: N/A
Date: 9-11-19	Date: 02/11/19	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

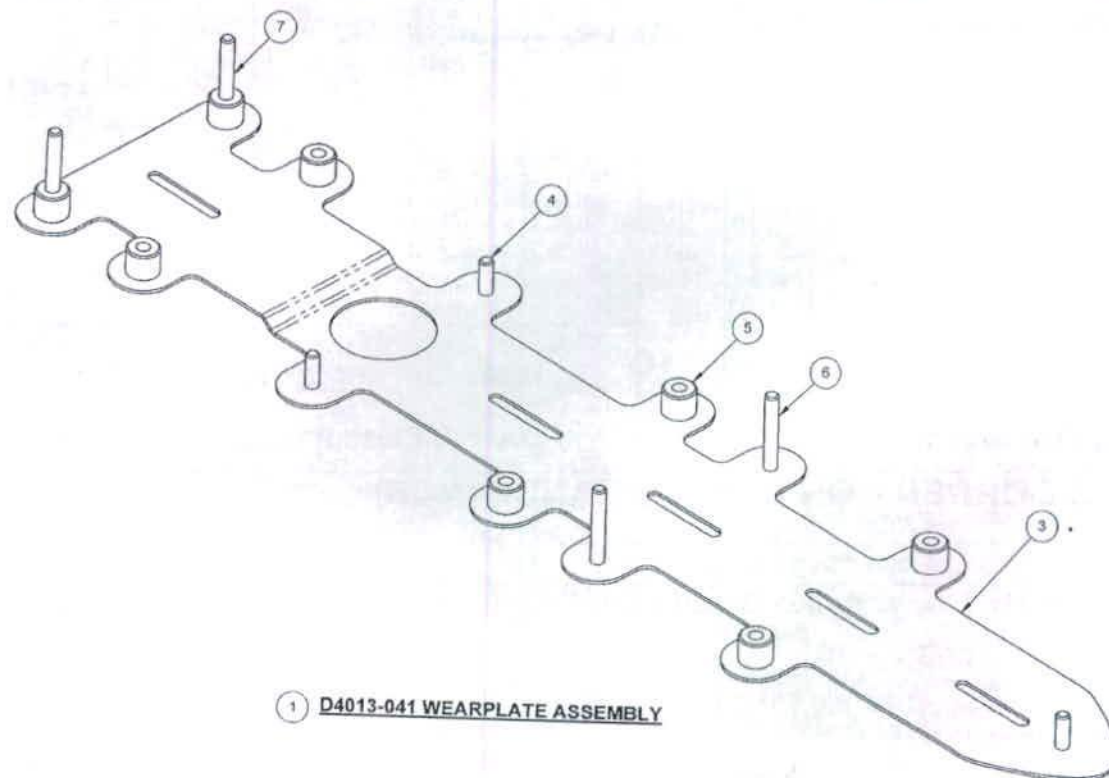
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NOTE: Date & initial all entries



1 D4013-041 WEARPLATE ASSEMBLY

ITEM	QTY -D41	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	AVR	2059B	HARDCOAT

C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 8, ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDTEX	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR	AS	D4013	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR	AS	WEARPLATE ASSEMBLY	NTS
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PRELIMINARY ISSUE

U

53625

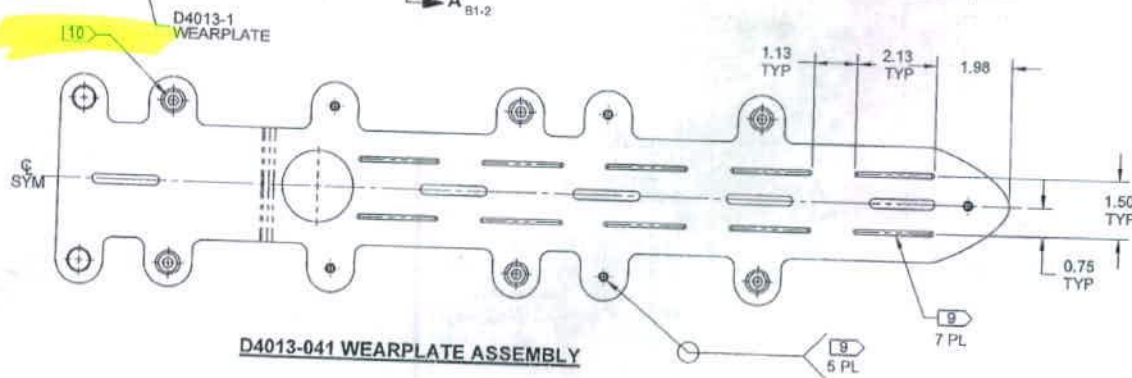
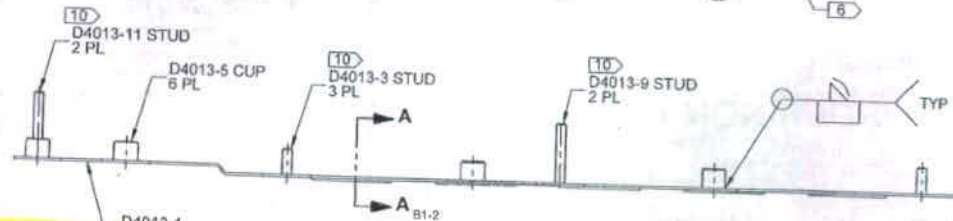
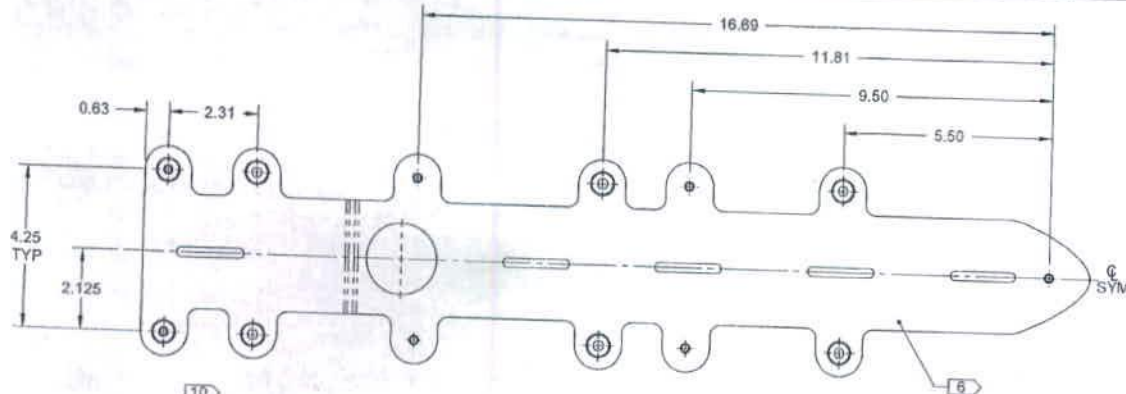
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

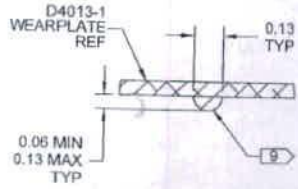
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4013-041 WEARPLATE ASSEMBLY

PRELIMINARY ISSUE



SECTION A-A B6-2 SCALE 6X

NOTES:

- 1) MATERIAL: SEE SHEETS 3 AND 4
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.89 lbs
- 8) WELDING: PER QSI 004
- 9) 2050B HARDCOAT WELD, 10 PL
- 10) MASK THREADS (7 PL) AND HEXAGONAL OPENINGS (6 PL) PRIOR TO PAINTING

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4013	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	09.11.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19.375 MAX IS ACCEPTABLE.
(40.005 ABOVE TOL)

106.11.20



1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: NONE
7) WEIGHT: 1.48 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DS	D4013	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	09.11.11	COPYRIGHT © 2005 BY DART AEROSPACE LTD.	

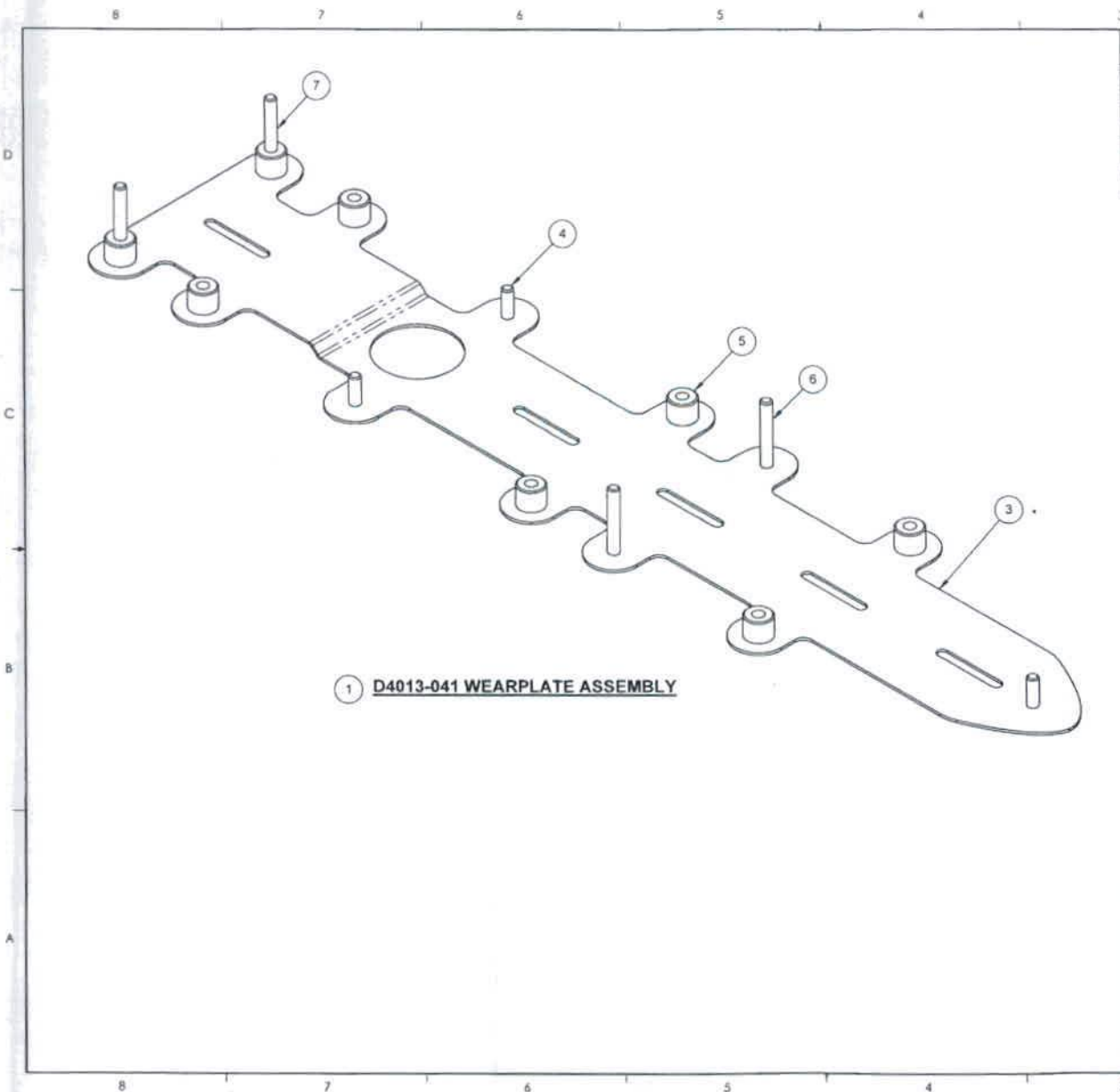
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1 D4013-041 WEARPLATE ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

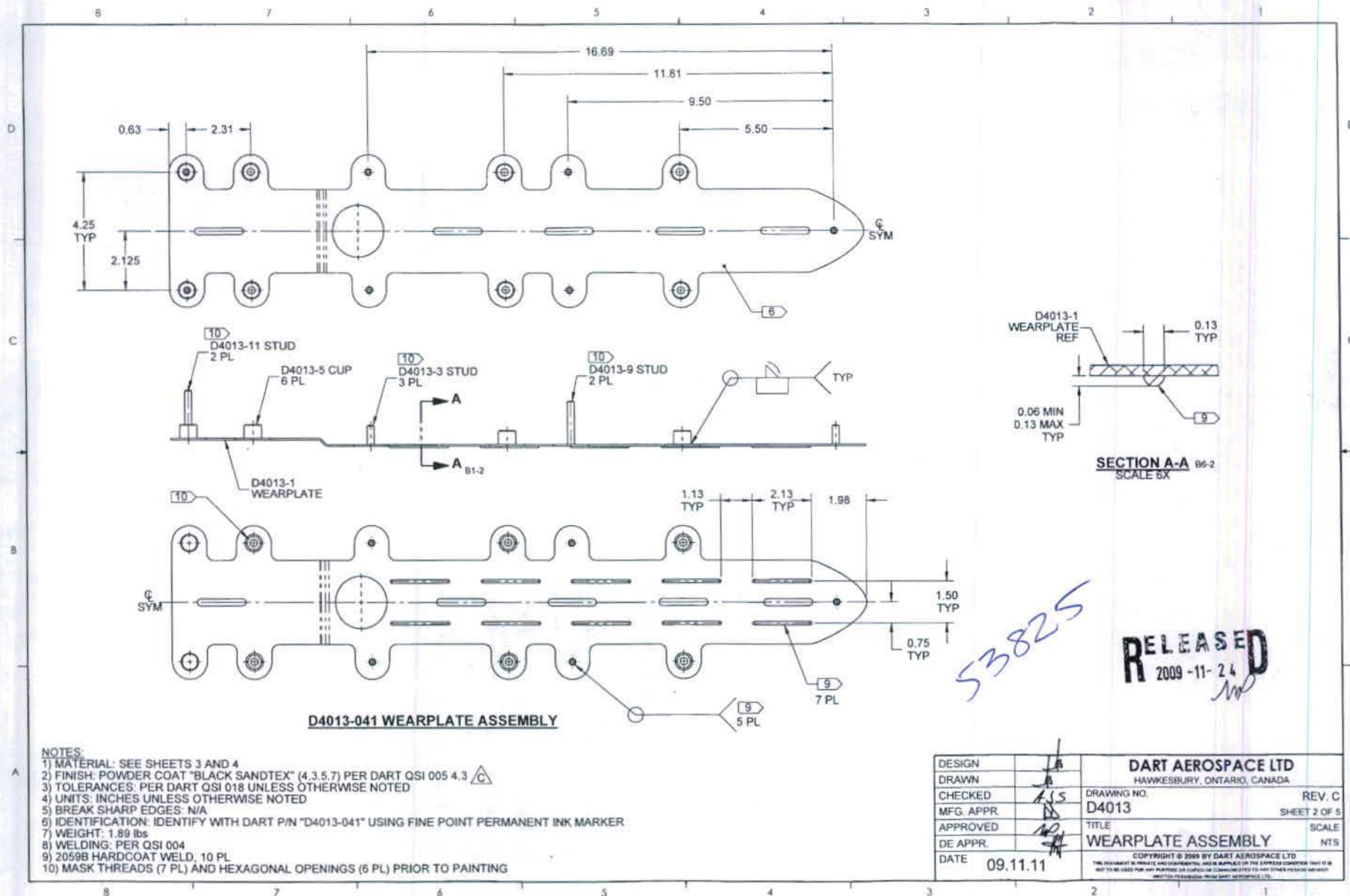
C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5, ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDTEX	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	09.11.11		

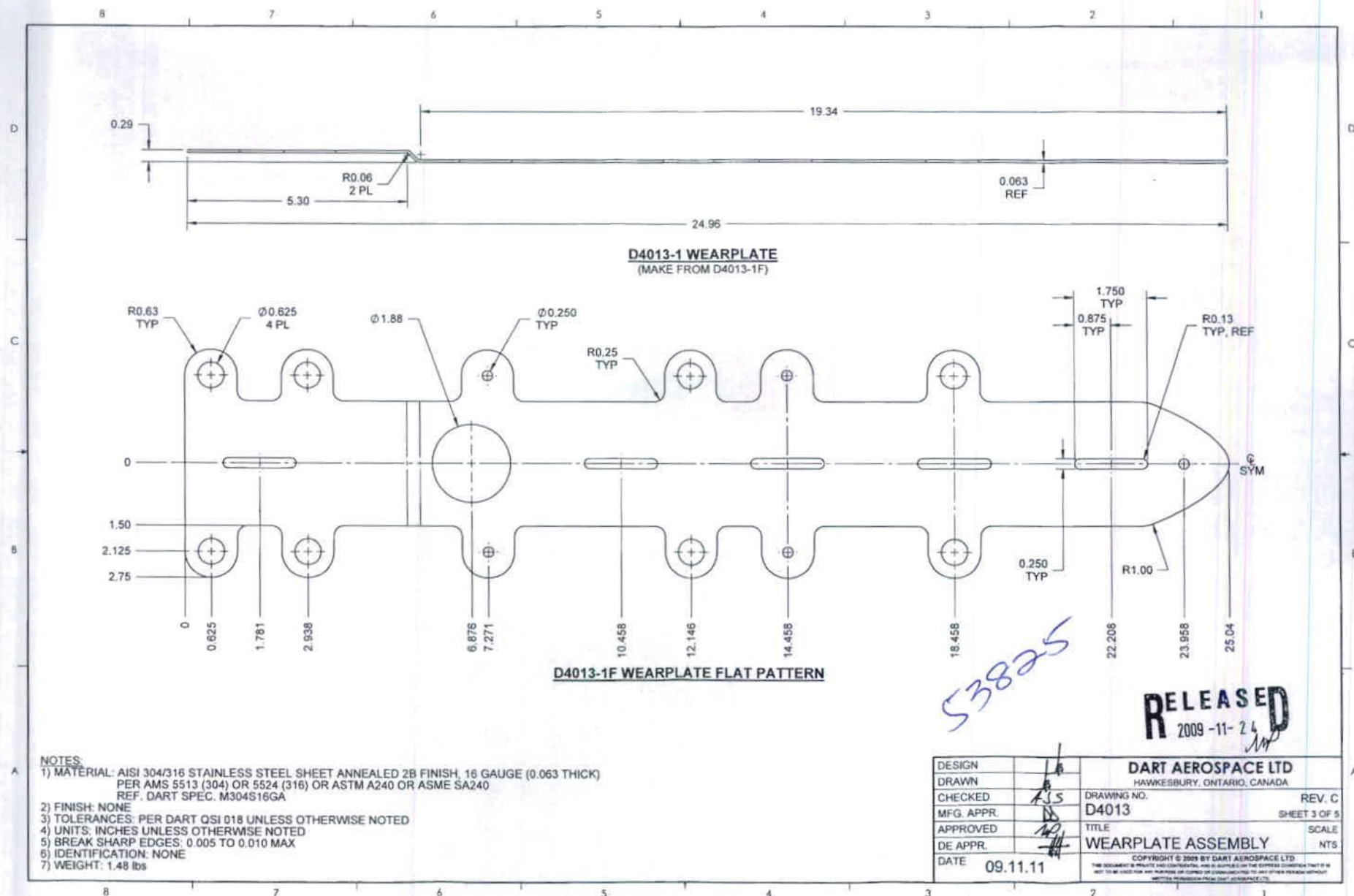
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2009-11-24
MP

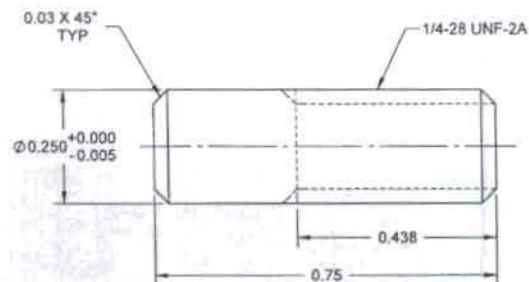
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HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4013
REV. C
SHEET 1 OF 5
TITLE
WEARPLATE ASSEMBLY
SCALE
NTS

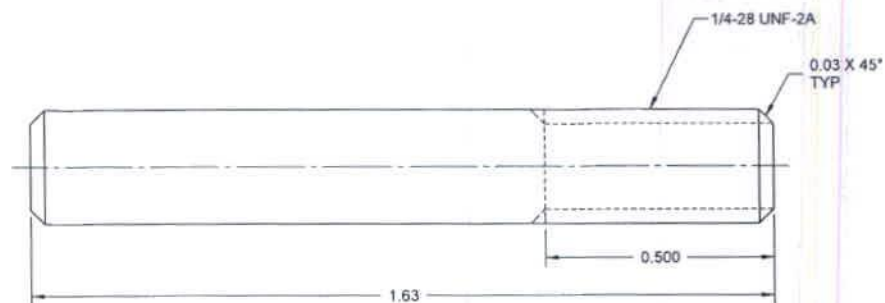
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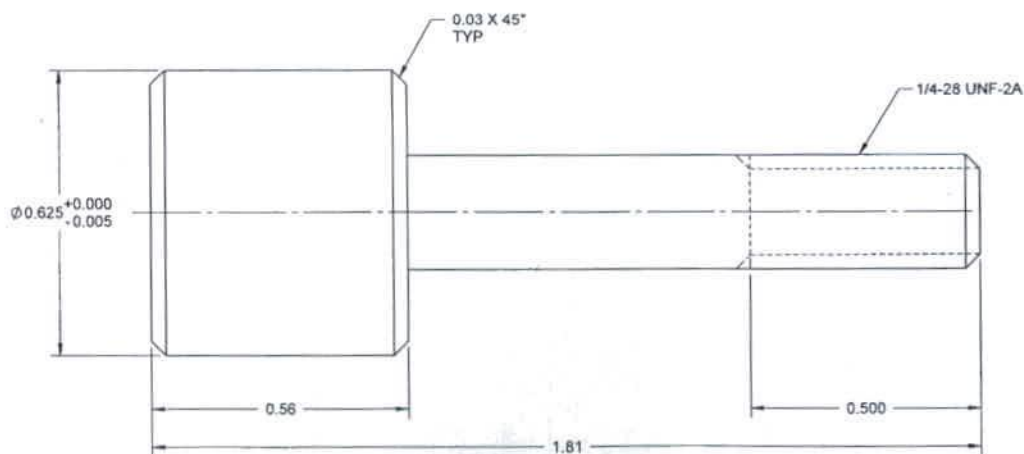




D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

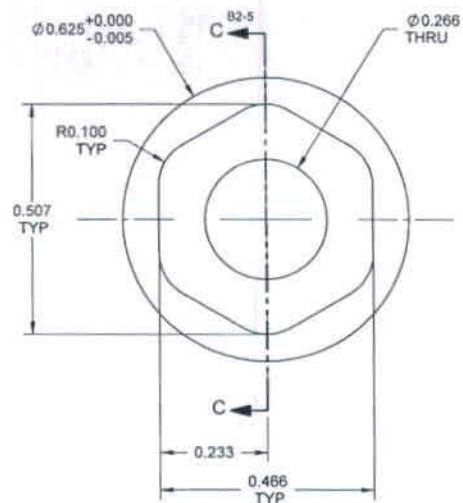
NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

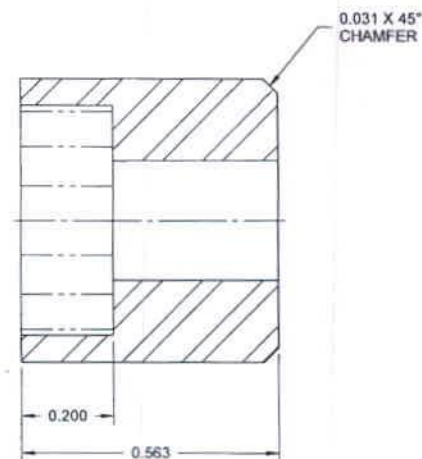
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JA</i>	DRAWING NO.	REV. C
CHECKED	<i>AS</i>	D4013	SHEET 4 OF 5
MFG APPR.	<i>BB</i>	TITLE	SCALE
APPROVED	<i>MA</i>	WEARPLATE ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED
2009-11-24

53825



D4013-5 CUP



SECTION C-C D6-5

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/5	DRAWING NO.	REV. C
MFG. APPR.	1/5	D4013	SHEET 5 OF 5
APPROVED	1/5	TITLE	SCALE
DE APPR.	1/5	WEARPLATE ASSEMBLY	NTS
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